

Date: Thursday, 14/05/2009 3:41:25 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING LUG
Job Number : 47969	
Estimate Number : 10428	
P.O. Number :	Part Number : D32351
This Issue : 14/05/2009 S.O. No. :	Drawing Number : D3235 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 46745	Material :
Written By :	Due Date : 21/05/2009 Qty: 100 Um: Each
Checked & Approved By : <u>Julie Dawson 05.14</u>	
Comment : Est A 04.04.19 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total : 7.1715 f(s)

Lug Extrusion

D2423 extrusion

Batch: 43722

S.P. 09/05/27 (100)

2.0	BAND SAW	BAND SAW
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**Comment:** Band Saw

Cut D2423 extrusion to 0.820"

Batch: 43722

S.P. 09/05/27 (100)

3.0	D32351P	lug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

lug

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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(100)

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA369 and Dwg D3235

2-Identify as D3235-1

3-Deburr

mm 09/06/02

S.P. 09/05/31

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(100)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mm 07/04/02

S.P. 09/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 14/05/2009 3:41:25 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

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Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC8

SECOND CHECK



DIP 09/06/03

100



Comment: SECOND CHECK

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



100

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FZ 09/06/04

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/06/09 100

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME: 1:00pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 1:30pm

9/6/09 09-06-09 100

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



100

Comment: INSPECT POWDER COAT

BR 09-06-9

11.0

PACKAGING 1

PACKAGING RESOURCE #1



100x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 411

9/6/10

SD

12.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/11

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-06-10

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47969
Description: Mounting Lug		Part Number: D3235-1
Inspection Dwg: D3235 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010	4.453	✓			
0.306	+/-0.010	.308	✓			
1.85	+/-0.030	1.853	✓			
R1.20	+/-0.010	1.207	✓			
R0.125	+/-0.010	.125	✓			
0.400	+/-0.010	.400	✓			
0.735	+/-0.030	.723	✓			
Ø0.505	+0.005/-0.000	.506	✓			
R0.38	+/-0.030	.380	✓			
3.700	+/-0.005	3.702	✓			
0.375	+/-0.010	.377	✓			
0.750	+/-0.010	.753	✓			
Ø0.257	+0.005/-0.000	.258	✓			
R0.380	+/-0.030	.380	✓			

Measured by: SP	Audited by: DTP	Prototype Approval:	N/A
Date: 6/15/30	Date: 09/06/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

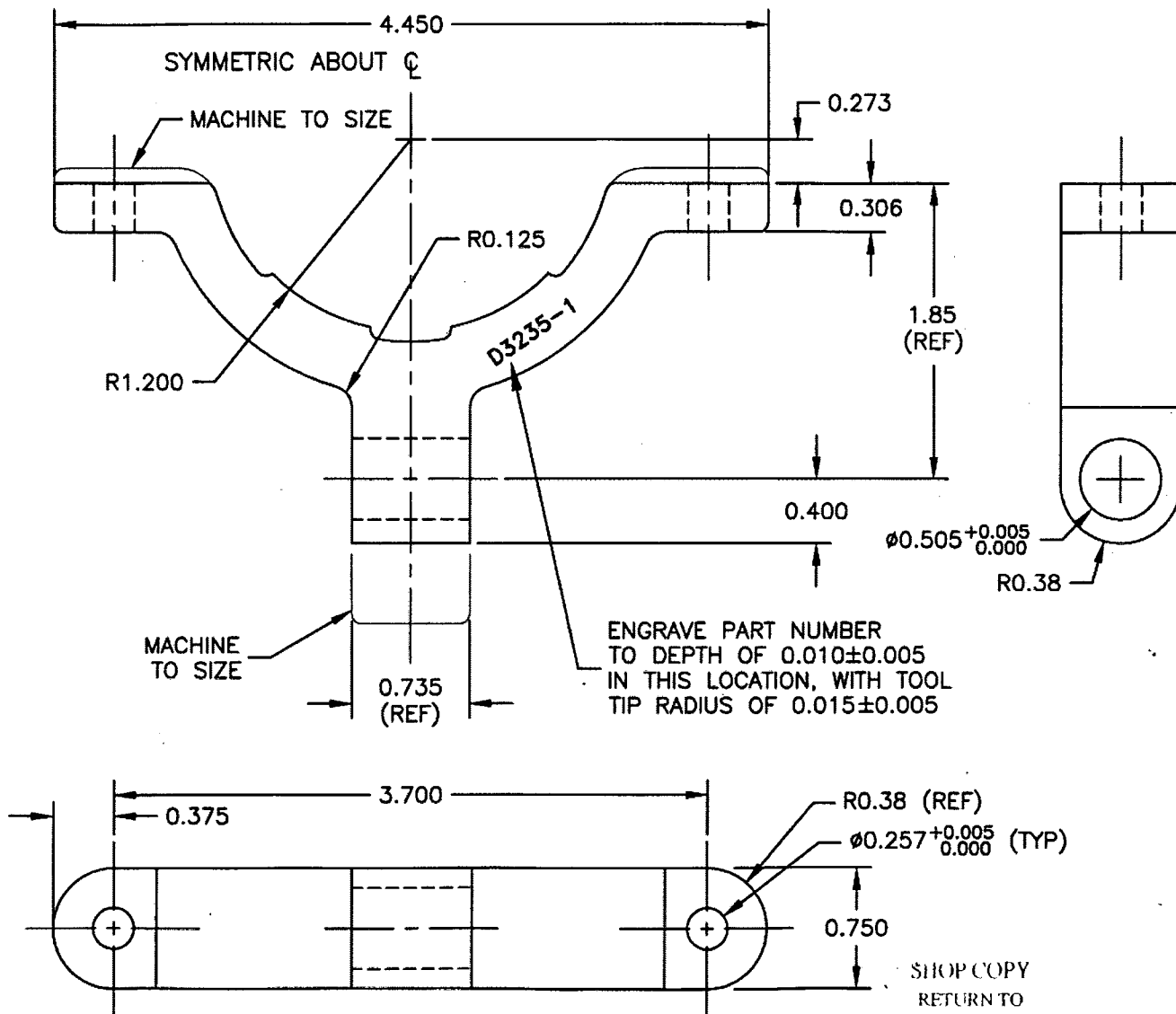
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED
040405



D3235-1 MOUNTING LUG

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47969

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